

Date: Thursday, 1/17/2008 3:32:06 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	HINGE BRACKET		
Job Number	36856		Part Number	D28582		
Estimate Number	10349		Drawing Number	D2858 REV B		
P.O. Number	:		Project Number	N/A		
This Issue	1/17/2008	S.O. No. :	Drawing Revision	B		
Prsht Rev.	NC		Material	:		
First Issue	/ /	Type : MACHINED PARTS	Due Date	2/10/2008	Qty:	24
Previous Run	36628		Um:	Each		
Written By	:					
Checked & Approved By	HJ 08/01/08					
Comment	Est C 00.06.22 Removed P/O for powder coat EC					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M6061T6B1500X01250	6061-T6 Bar 1.5" x 1.25"
Comment: Qty.: 0.1767 f(s)/Unit Total : 4.2412 f(s) Material: 1.50" X 1.25" 6061-T6 (QQ-A-225/8 or QQ-A-250/11 or QQ-A-200/8) (M6061T6B15001250) Batch <u>01/04/12</u>		
2.0	BAND SAW	BAND SAW
Comment: BAND SAW Cut blanks 6.02" Note: 1 Blank Makes 3 Parts		
3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
Comment: HAAS CNC VERTICAL MACHINING #1 Machine per folio D2858-2		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: ~~01/01/02~~ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 36856		Part Number: D28582
Job Number:		
Seq. #:	Machine Or Operation:	Description :
5.0	QC8	SECOND CHECK
Comment: SECOND CHECK		8F 08/02/15
6.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Tumble 2-Deburr any rough edges after tumbling		8F 08/02/19
7.0	QC5	INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP		8F 08/02/19 X24
8.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.3		BL 08-02-19 24
9.0	POWDER COATING	POWDER COATING M107005
Comment: POWDER COATING Powder Coat Gloss White (Ref. 4.3.5.1) per Dart QSI 005 4.3		M-1 08/02/19 24X
10.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION JL
Comment: INSPECT POWDER COAT		08-02-19 24X
11.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 81		8/2/19 SP 24X
12.0	QC21	FINAL INSPECTION/W/O RELEASE
Comment: FINAL INSPECTION/W/O RELEASE		D 08/02/20
Job Completion		2008/2/20 24 W

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	36856
Description: Hinge Bracket	Part Number:	D2858-2
Inspection Dwg: D2858 Rev: B		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.171	+0.005/-0.000	.171	✓			
Ø0.400	+0.005/-0.000	.400	✓			
R0.125	+/-0.010	.125	✓			
0.328	+/-0.010	.328	✓			
0.820	+/-0.005	.819	✓			
1.476	+/-0.010	1.477	✓			
0.342	+/-0.010	.342	✓			
0.875	+/-0.010	.875	✓			
1.56	+/-0.030	1.564	✓			
0.147	+/-0.010	.149	✓			
0.717	+/-0.010	.722	✓			
0.697	+/-0.010	.695	✓			
0.229	+/-0.010	.233	✓			
R0.125	+/-0.010	.125	✓			
R0.063	+/-0.010	.063	✓			
0.063	+/-0.010	.062	✓			
0.126	+/-0.010	.126	✓			
0.630	+/-0.010	.627	✓			
R0.354	+/-0.010	.354	✓			
0.965	+/-0.010	.969	✓			
Ø0.166	+0.005/-0.000	.168	✓			

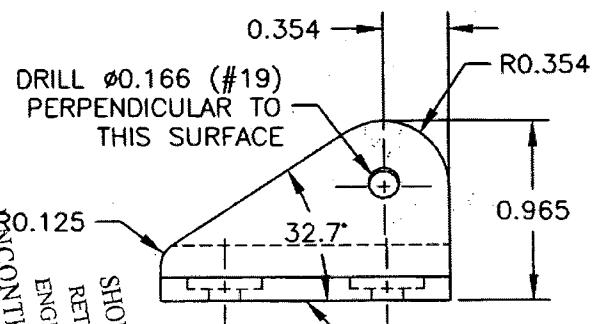
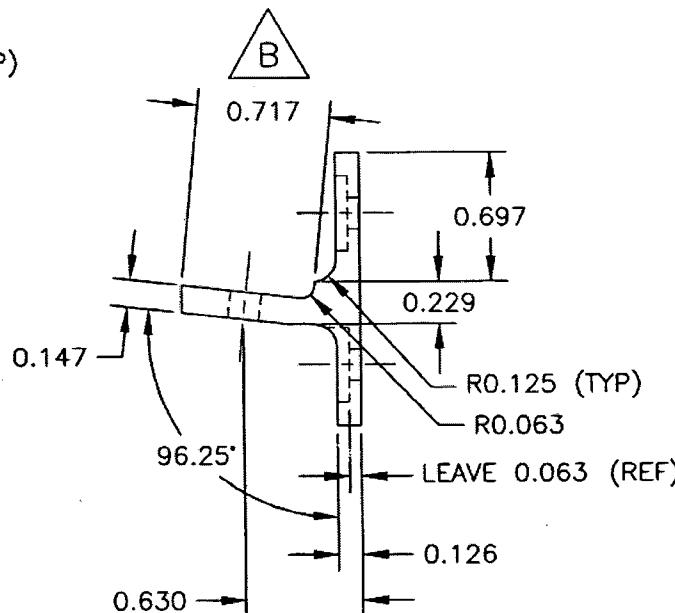
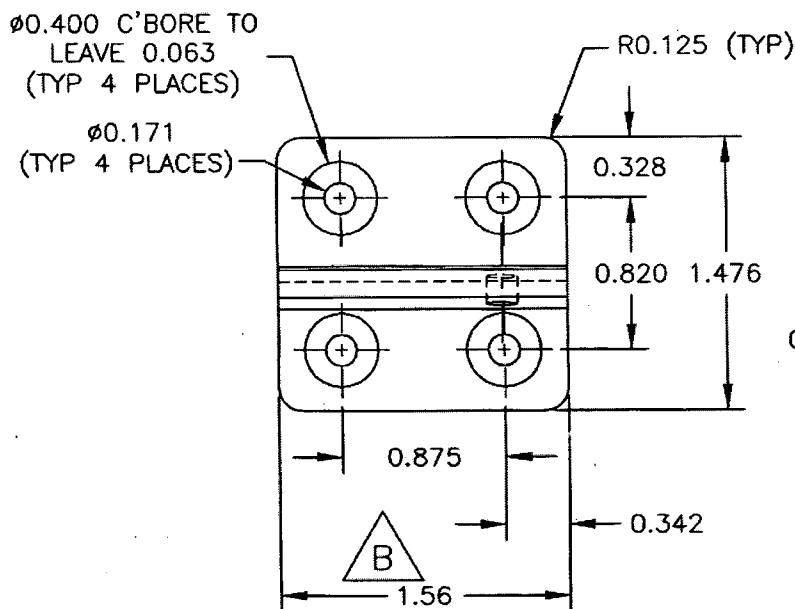
Measured by:	J.L	Audited by:	S.F	Prototype Approval:	N/A
Date:	08/02/15	Date:	08/02/15	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.11.11	New Issue	KJ/JLM	S.J.

DART**RELEASED**

[REASON KEY]

DESIGN	DRAWN BY	DART AEROSPACE LTD
KF	KE	HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
CP	JR	D2858
DATE		SHEET 1 OF 1
99.02.28		
A	98.12.14	SCALE
B	99.02.28	1:1



ENGRAVE P/N CENTERED ON
BASE 0.003 DEEP (0.010 MAX)

D2858-1 SHOWN
D2858-2 OPPOSITE

MATERIAL: 6061-T6 ALUMINUM (QQ-A-250/11) OR (QQ-A-200/8) OR (QQ-A-225/8)
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1

POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

NO. 36850
WORK ORDER
SUBJECT TO AMENDMENT
WITHOUT NOTICE
ENGINEERING COP
SHOP COP
RETURN TO
D2858